

Work Order ID 163680

Thursday, July 06, 2017 7:14:15 AM

163680

Ship 10th July

Page 1

Item ID: D2569 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge
 Start Date: 7/6/2017 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/10/2017 Req'd Qty: 2.00 *2* Customer:

Reference:

DAS
21
9-89

Approvals: Process Plan: _____ Date: JUL 06 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2569	Rev B

100 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

100

Powdercoat

Powder Coating

M 137176.

Memo

Note: Advise that hinges are to be broken back and forth immediately after to ensure free mobility of hinge.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45.
400°
9:15.

2 17-07-10 DAS 38 9-89

110

QC3- Inspect Part Finish

0.00

110

QC

Quality Control

Memo

0.02

2

DAS
38
9-89

JUL 10 2017

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Page 2

Item ID: D2569

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge

Start Date: 7/6/2017 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/10/2017 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <i>Sold</i>	0.00				<i>2</i>	<i>1-89</i>	<i>245</i>	<i>JUL 10 2017</i>
120									
Packaging	Memo	0.02							
Packaging	Location : CA2								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.20							
Quality Control									

JUL 10 2017

Picklist Print

Thursday, July 06, 2017 7:14:14 AM

Page 1

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163680

Parent Item: D2569

D2569

Parent Item Name: Hinge

Start Date: 7/6/2017

Required Date: 7/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D01.12.17Changed processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200		Purchased	No			100	f	13.7960	6	12			
MS20257-3-7200									**				
PIANO HINGE													

Location

Loc Qty

Loc Code

ST479a

13.796

m135544

0.6

m135774

0.296

m137361

0.9

m137587

12

DAS
6
9-89

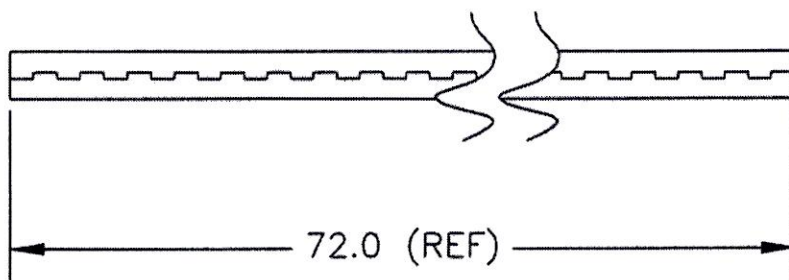
JUL 06 2017

12



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DA</i>	DRAWING NO. D2569	REV. B SHEET 1 OF 1
DATE 99.01.05		TITLE HINGE	SCALE 1:4
A	96.06.24	NEW ISSUE	
B	99.01.05	ADDED MS20257-3-7200 AND P/C REMOVED HOLE PATTERN	

RELEASED
99.01.21 *KE*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163680 M.C.
170746

NOTES:

- 1) MAKE FROM MS20257-3-7200
- 2) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ENSURE HINGE MOVEMENT IS MAINTAINED IMMEDIATELY AFTER POWDER COAT
- 4) USE 0.040 LOCKWIRE TO SECURE HINGE PIN AT BOTH ENDS (USE #60 DRILL FOR LOCKWIRE HOLE)